

# Work Order ID 67007



Page 1

Thursday, March 03, 2011 10:47:56 AM

Item ID: K642-511

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-511

Start Date: 3/3/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 11-03-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels per PPP K642-511

CHG004

 CL 11-5-30  
(WHITE LABEL ONLY)

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

SB (3) 11/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval, QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Revision ID:

Stop



Item Name: saddle kit 642-511

Start Date: 3/3/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K642-511 Location: \_\_\_\_\_

ReoB

11/6/08 (30)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/08  
MF  
11-06-08

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# Picklist Print

Thursday, March 03, 2011 10:48:03 AM

Page 1

Work Order ID: 67007

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 3/3/2011


Required Date: 3/7/2011


Start Qty: 3.00


Required Qty: 3.00

Comments: IPP Rev:A 07.06.05 new issue EC  
IPP Rev.B 08.02.05, Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C35A		Purchased	No			110	Each	64.0000	3	9			
<div style="display: flex; justify-content: space-between;"> <div>  <p>BOLT</p> </div> <div> <p>Location</p> <p>ST353</p> <p>111724</p> <p>114523</p> <p>116082</p> <p>116924</p> </div> <div> <p>Loc Qty</p> <p>64</p> <p>1</p> <p>30</p> <p>3</p> <p>30</p> </div> <div> <p>Loc Code</p> <p></p> <p></p> <p></p> <p></p> <p></p> </div> </div>													

AN3C36A		Purchased	No			110	Each	40.0000	9	27			
<div style="display: flex; justify-content: space-between;"> <div>  <p>BOLT</p> </div> <div> <p>Location</p> <p>ST353</p> <p>109771</p> <p>116381</p> <p>116590</p> </div> <div> <p>Loc Qty</p> <p>40</p> <p>6</p> <p>2</p> <p>32</p> </div> <div> <p>Loc Code</p> <p></p> <p></p> <p></p> <p></p> </div> </div>													

AN3C41A		Purchased	No			110	Each	11.0000	8	24			
<div style="display: flex; justify-content: space-between;"> <div>  <p>BOLT</p> </div> <div> <p>Location</p> <p>FG</p> <p>103324</p> <p>ST354</p> <p>116381</p> </div> <div> <p>Loc Qty</p> <p>4</p> <p>4</p> <p>7</p> <p>7</p> </div> <div> <p>Loc Code</p> <p></p> <p></p> <p></p> <p></p> </div> </div>													

116082 X 3

116924 X 6

117125

117163

11/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval, QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, March 03, 2011 10:48:03 AM

Page 2

Work Order ID: 67007

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 3.00

Required Qty: 3.00

AN4C6A

Purchased

No

110

Each

307.0000

12

36

✓



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

203

113121

1

115016

16

116003

136

116400

50

ST358

100

116704

100

116003 x 5

116400 x 33

24

AN5C11A

Purchased

No

110

Each

93.0000

8

24

✓



Bolt

Location

Loc Qty

Loc Code

FG

3

104817

3

ST338

90

114443

14

116075

26

116381

50

116075

AN5C12A

Purchased

No

110

Each

52.0000

4

12

✓



BOLT

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

50

113121

42

116075

8

116075 34

M/17313 SPFB 11/05/25

Thursday, March 03, 2011 10:48:03 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 67007

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 3.00

Required Qty: 3.00

AN5C13A

Purchased

No

110

Each

70.0000



4

12

*JB*

BOLT

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

68

116075

68

116075

AN5C15A

Purchased

No

110

Each

45.0000



1

3

*JB*

Bolt

Location

Loc Qty

Loc Code

ST339

45

111819

45

111819

AN5C32A

Purchased

No

110

Each

86.0000



2

6

*JB 4/05/25*

Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

82

113164

32

116380

50

113164

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, March 03, 2011 10:48:04 AM

Page 4

Work Order ID: 67007

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 3.00

Required Qty: 3.00

AN5C34A Purchased No

110 Each

48.0000

2

6

✓



*JB*

## Location

## Loc Qty

## Loc Code

FG

2

18918

2

ST340

46

111648

4

112454

42

*112454*

AN5C35A Purchased No

110 Each

65.0000

1

3



*JB*

## Location

## Loc Qty

## Loc Code

ST340

65

108084

22

108407

43

*108084*

AN960C10L NAS1149C0332 Purchased No

110 Each

61.0000

24

72

✓



*117291*

*JB*

## Location

## Loc Qty

## Loc Code

ST245

61

107534

59

108246

2

AN960C416L NAS1149C0432 Purchased No

110 Each

19.0000

24

72

✓



*116900*

*JB*

*11/05/25*

## Location

## Loc Qty

## Loc Code

ST346

19

112828

19

Thursday, March 03, 2011 10:48:04 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, March 03, 2011 10:48:04 AM

Work Order ID: 67007

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 3.00

Required Qty: 3.00

AN960C516L NAS1149C0532 Purchased No

110 Each

6.0000

8

24



WASHER



116289

fb

## Location

## Loc Qty

## Loc Code

ST347

6

111916

6

D206-648-013 *467002* Manufactured No

110 Each

0.0000

1

3



GHW Modification

D2652 Manufactured No

110 Each

325.0000

16

48



Bushing



67256

fb

## Location

## Loc Qty

## Loc Code

FG

44

31985

44

ST019

281

64770

54

65049

106

66124

121

D2712 Manufactured No

110 Each

358.0000

10

30



Set Screw



65115

fb 11/05/25

## Location

## Loc Qty

## Loc Code

FG

50

29962

50

ST021

308

61331

58

65115

250

65115

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, March 03, 2011 10:48:04 AM

Work Order ID: 67007

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 3.00

Required Qty: 3.00

D2932-1  
Saddle LH Out, 206

Manufactured No

110 Each

1.0000

Location

Loc Qty

Loc Code

ST428

1

66634

1

110 Each

0.0000

D2933-1  
Saddle LH In, 206

Manufactured No

D2934  
Saddle Spacer

Manufactured No

110 Each

29.0000

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

23

66043

23

110 Each

88.0000

D2935  
Saddle Spacer

Manufactured No

Location

Loc Qty

Loc Code

ST027

88

63558

17

66564

71

110 Each

0.0000

D2938-1  
Saddle LH Out, 206

Manufactured No

D2939-1  
Saddle LH In, 206

Manufactured No

110 Each

0.0000

1 3 ✓  
67790x2gB  
B690321x  
1 3  
B69030 ul/psf  
2 6 ✓  
67585 gB  
2 6 ✓  
gB  
1 3  
69033 ul/psf  
1 3  
676142x  
676142x  
B6902810 ul/psf

Thursday, March 03, 2011 10:48:05 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, March 03, 2011 10:48:05 AM

Page 7

Work Order ID: 67007

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 3.00

Required Qty: 3.00

D3396-3 Manufactured No

110 Each

50.0000

2

6



Spacer



## Location

## Loc Qty

## Loc Code

FG

10

26772

10

ST052

40

66488

40

D3407-043 Manufactured No

110 Each

3.0000

1

3

D3407-043



Tow Ring



## Location

## Loc Qty

## Loc Code

ST420

1

62627

1

ST464

2

50387

1

64071

1

D3456-1 Manufactured No

110 Each

28.0000

1

3

D3456-1



Washer



## Location

## Loc Qty

## Loc Code

ST058

28

63239

2

64282

26

JB

66488  
68339 JB

(-2) 11/16/13

369540 34 11/16/18

66848 11/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, March 03, 2011 10:48:05 AM

Work Order ID: 67007

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Parent Item Name: saddle kit 642-511

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 3.00

Required Qty: 3.00

D3457-1

Manufactured No

110 Each

33.0000

2

6



Washer



67779

JB 11/05/25

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

23

45913

1

66030

22

D3672-1

Manufactured No

110 Each

939.0000

24

72



Phenolic Washer



JB

JB

Location

Loc Qty

Loc Code

ST077

939

42329

10

52505

29

64177

900

52505 10X

64177 62X

72

D3672-3

Manufactured No

110 Each

802.0000

24

72



Phenolic Washer



JB

JB

Location

Loc Qty

Loc Code

ST077

802

64176

802

64176

72

D3672-7

Manufactured No

110 Each

884.0000

24

72



Phenolic Washer



JB

JB 11/05/18

Location

Loc Qty

Loc Code

ST077

884

53237

244

64175

640

64175

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, March 03, 2011 10:48:05 AM

Page 9

Work Order ID: 67007

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 3.00

Required Qty: 3.00

MS21043-3

Purchased

No

110

Each

1,172.000

20

60

✓



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1096

112314

1096

MS21043-4

Purchased

No

110

Each

892.0000

13

39

✓



Nut

Location

Loc Qty

Loc Code

ST301

892

114523

5

114784

2

115936

22

116188

563

116549

300

MS21043-5

Purchased

No

110

Each

542.0000

4

12

✓



Nut

Location

Loc Qty

Loc Code

ST300

100

116548

100

ST301

442

112314

442

112314

Thursday, March 03, 2011 10:48:05 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## 4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
1	1	1	X			D206-642-541	SKIDTUBE
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
1	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP <sup>(1)</sup>
4			2			AN3C4A	* BOLT <sup>(1)</sup>
5A			2			AN960C10L	* WASHER <sup>(1)</sup>
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) <sup>(1)</sup>
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (or AN5C12A)	* BOLT <sup>(2)</sup>
14	4	4				AN5C11A (or AN5C13A)	* BOLT <sup>(2)</sup>
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD <sup>(1)</sup> (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD <sup>(1)</sup> (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET <sup>(1)</sup>
23A			1	1		D3535-23	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET <sup>(1)</sup>
24A			1	1		D3535-39	* WEARSHOE <sup>(1)</sup> (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET <sup>(1)</sup>
25A			1	1		D3535-35	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET <sup>(1)</sup>
26A			78	78		AN3C4A	* BOLT <sup>(1)</sup>
26B			78	78		AN960C10L	* WASHER <sup>(1)</sup>
26C			78			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

continued on next page...

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D206-642  
Page 26 of 34

continued from previous page...

ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE  
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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